

5

DEVIATION

3938



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBIR7028-1

Job Sheet 178595



SHIP

7-26

Folio
7-24

Part No: RBIR7028-1

Job Qty: 6 ea

Part Name: Receiver



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/4/18

Job Tracking No:

Due Date: 7/9/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBIR7### Rev. 0 IPP Rev. A 18.06.04 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/9/18	7/9/18	0.00	0.00	Start Up Machining-3	man	JB 18-08-07
110	Mori Seiki	6 pcs	7/9/18	7/9/18	0.00	3.00	MORI SL-154	11	JB 18-08-07
120	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC2 Machining-4	11	JB 18-08-07
150	Lathe Conv	6 pcs	7/9/18	7/9/18	0.00	1.20	Lathe Conv-1		452018-08-07
160	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC2 Machining-5		8-86 18-08-16
170	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC8 Machining-4		
180	Outsource	6 pcs	7/9/18	7/9/18	0.00	0.00	Outsource12		
190	Packaging	6 pcs	7/9/18	7/9/18	0.00	0.00	Packaging2		DL
200	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC6		
210	Packaging	6 pcs	7/9/18	7/9/18	0.00	0.00	Packaging3-1		DMU
220	QC21-SA	6 Ea	7/9/18	7/9/18	0.00	0.00	QC21		21 AUG 16 2018

Part Op 110 - 1-Machine as per folio FC 253 FOLIO REV: DWG REV: 2-Deburr

Descriptions: 150 - Machine as per DWG. Face and chamfer.

170 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

180 - Issue P/O to GROUPE ALTECH; PO - Black oxide finish, MIL-C-13924C Class 1 - Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required

NOT REQUIRED IF MADE FROM SS make JULY 26/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R1.375	M1018R1.375	.8700 ft (.145 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R1.375	1	12	0

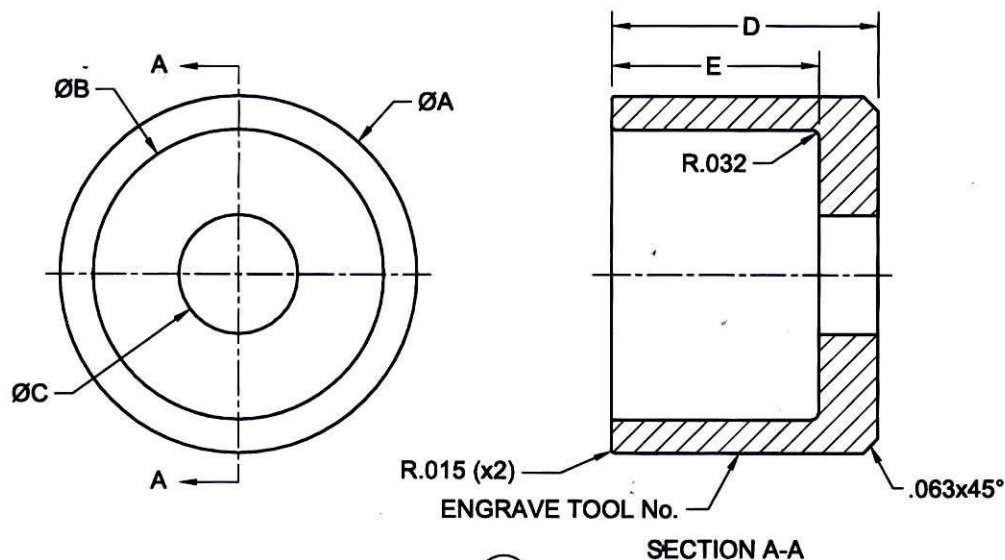
Part Specifications

Specifications could not be found.

Plex 7/16/18 10:50 AM dart.logan.david

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REV	DESCRIPTION	REVISIONS		
		DATE	INITIAL	APPROVED
-	-	-	-	-



-1

RECEIVER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 17834
20180716

TOOL #	ØA +010 -010	ØB +005 -005	ØC +005 -000	D +010 -010	E +010 -010	MATERIAL	SPECIFICATIONS
RBIR7028	1.375	1.038	.313	1.312	1.062	1018	Ø1-3/8 x 1-1/8

RED BARN MACHINE	
TITLE PORTABLE BEARING INSTALL & REMOVAL TOOLS; RECIEVER	
DWG NO. CHARTED TOOL No. -1	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE CHART
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE NTS DATE 10-22-10 SHEET 2 of 5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>RBIR7028 Rev. N/A</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Feb 27, 2018																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
RBIR7028-1/-3/-5 can be manufactured from 17-4PH-H900 as an alternative material Heat treat and Black Oxide is not required if the part is manufactured from 17-4PH-H900				- This deviation is acceptable. - The fit, form and function of the part will be as originally intended.																					
Root Cause				FAULT CATEGORY																					
Environment	☐		No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong														
Design	☐		Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions														
Doc/Data	☐		Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance														
Equip/Tooling	☐		Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect														
Handling/Pre	☐		Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing														
Material	☐		Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved														
Internal Transport	☐		Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing														
Tribal Knowledge	☐		Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish														
LOA	☐		Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread														
Substation	☐		Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence														
Past Expiry Date	☐		Manufacturing Process	☐																					
Misidentified	☒		Past Due	☐	OTHER :																				



Container No: S099616



Part: RBIR7028-1

Job No: 178595

Serial No/Batch: S099616

Revision: 0

Inspector:

Exp Date:

Instructions:

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CANADA
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www.dartaerospace.com

Date: 08/07/10